

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018739**Date Inspected:** 17-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Zhu Zhong Hai.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

OBG TRIAL ASSEMBLY**OBG Segment 12AE**

This QA Inspector observed ZPMC qualified welding personnel identified as 053871 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE Edge plate I rib Hold back area Cross beam side. Joint identified as EP3001-001-058~60. ZPMC QC Identified as Wang Li Yang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114-FCM-1.

OBG Segment 12BE

This QA Inspector observed ZPMC qualified welding personnel identified as 053871 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12BE Edge plate I rib Hold back area Cross beam side. Joint identified as EP3002-001-006, 008. ZPMC QC Identified as Wang Li Yang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114-FCM-1.

OBG Segment 12AW~12BW

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This QA Inspector observed ZPMC qualified welding personnel identified as 040656 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW+12BW Edge plate to Side plate hold back area. Joint identified as SEG3004AA-022 and CA3009-002. ZPMC QC Identified as Wang Zhu. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1. For more information see below attached picture number 1.

OBG Segment 12AE ~ 12BE

This QA Inspector observed ZPMC qualified welding personnel identified as 052763, 040367 Perform Flux Core Arc Welding (FCAW) on OBG segment 12AE+12BE Side plate to Side plate joint Cross beam side. Joint identified as OBE12D-002. ZPMC QC Identified as Wang Li Yang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231T-ESAB. For more information see below attached picture number 2.

OBG Segment 12AE~12BE

This QA Inspector observed ZPMC qualified welding personnel identified as 047353 Perform Flux Core Arc Welding (FCAW) on OBG segment 12AE+12BE Deck plate to deck plate joint Bike path side. Joint identified as CA6502-009. ZPMC CWI Identified as An Qing Xiang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231T-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone :150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer